

Work Order ID 74027

Tuesday, September 20, 2011 1:09:11 PM



Page 1

Item ID:	D3213-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Door Panel					
Start Date:	9/20/2011	Start Qty:	10.00		Cust Item ID:	
Required Date:	10/3/2011	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>P</u>	Date:	<u>11-09-20</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3213	B								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet									
2024.063									

131-10-26

(10)

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

131-10-26

P10 →

120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

5 11/10/28

(45) (10)

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W/O: 74027		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3213-3 PAR #: N/A Fault Category: Small FAB NCR: Yes No DQA: 11 Date: 11.11.03
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 11/11/04

NCR: 11-953		WORK ORDER NON-CONFORMANCE (NCR) 5.11						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/10/28	#100	Found QH x1 with cut out in Bottom of Part. P.C. too close to edge of sheet. LQA.	S 11/10/28 ASTWZ	Scrap + Destroy no Repair QH x1	OK 11.10.28	S 11/10/28	S ASTWZ 11/10/28	S 11/10/28

NOTE: Date & initial all entries

Work Order ID 74027

Tuesday, September 20, 2011 1:09:11 PM



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Item ID: D3213-3

Accept



Setup Start



Revision ID:

Item Name: Door Panel

Stop



Start Date: 9/20/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/3/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
	Small Fab								
Small Fab	Memo Deburr	0.00							
140	Chemical Conversion Coat per QSI005 4.1	0.00							
	HandFinish								
Hand Finishing	Memo	0.00							
150	QC3- Inspect Part Finish	0.00							
	QC								
Quality Control	Memo	0.00							

B11-10-28



9 11-10-31

PX / m / 11/10/31

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 74027

Tuesday, September 20, 2011 1:09:11 PM



Page 3

Item ID: D3213-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Panel

Start Date: 9/20/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/3/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: 232

0.00



Packaging

Memo

0.00

Packaging

11/10/11



170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/11

mf

11-10-31

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 20, 2011 1:09:15 PM

Page 1

Work Order ID: 74027



Parent Item: D3213-3



Parent Item Name: Door Panel

Start Date: 9/20/2011

Required Date: 10/3/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 05-11-17 JLM
IPP Rev:B Now on Waterjet 07-02-13 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.063

Purchased

No

100

sf

116.5000

0.4714

4.962105



BITU-2C

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT022

116.5

117392

116.5

117392

10

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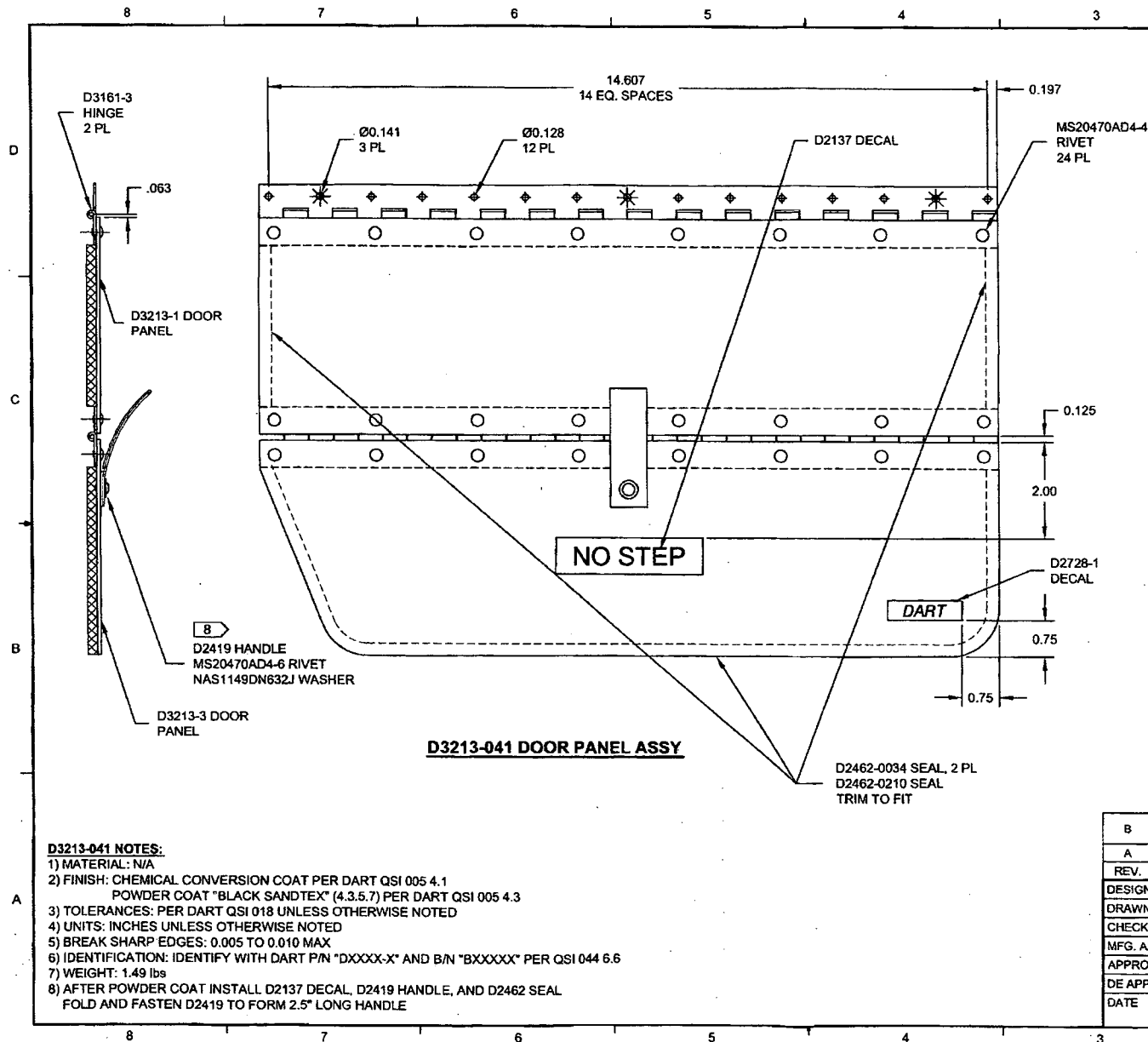
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



QTY -041	PART NUMBER	DESCRIPTION
X	D3213-041	DOOR ASSEMBLY
1	D2419	HANDLE
2	D2462-0034	SEAL
1	D2462-0210	SEAL
1	D2728-1	DECAL
1	D2137	DECAL
2	D3161-3	HINGE
1	D3213-1	DOOR PANEL
1	D3213-3	DOOR PANEL
1	NAS1149DN632J	WASHER (OR AN960JD6)
24	MS20470AD4-4	RIVET
1	MS20470AD4-6	RIVET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74027

RELEASED
2011-06-10

B	FORMAT TO CURRENT STD; ADD D3213-041B REASON: PAR11-109.	MB	11.06.06
A	NEW ISSUE	CP	03.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.06.06		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3213
TITLE DOOR ASSEMBLY

REV. B
SHEET 1 OF 4
SCALE NTS

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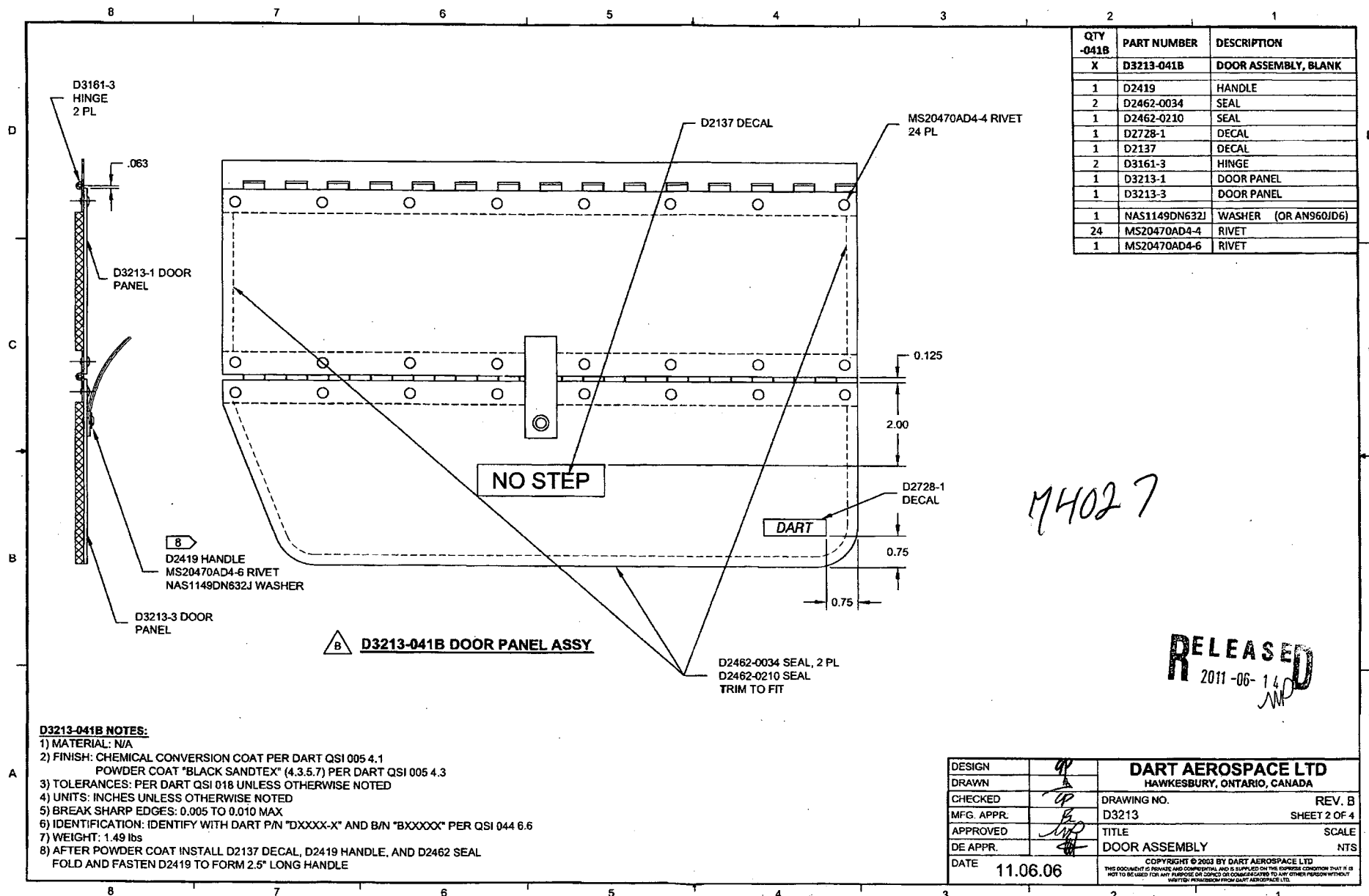
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QTY -041B	PART NUMBER	DESCRIPTION
X	D3213-041B	DOOR ASSEMBLY, BLANK
1	D2419	HANDLE
2	D2462-0034	SEAL
1	D2462-0210	SEAL
1	D2728-1	DECAL
1	D2137	DECAL
2	D3161-3	HINGE
1	D3213-1	DOOR PANEL
1	D3213-3	DOOR PANEL
1	NAS1149DN632J	WASHER (OR AN960JD6)
24	MS20470AD4-4	RIVET
1	MS20470AD4-6	RIVET

RELEASED
2011-06-14

74027

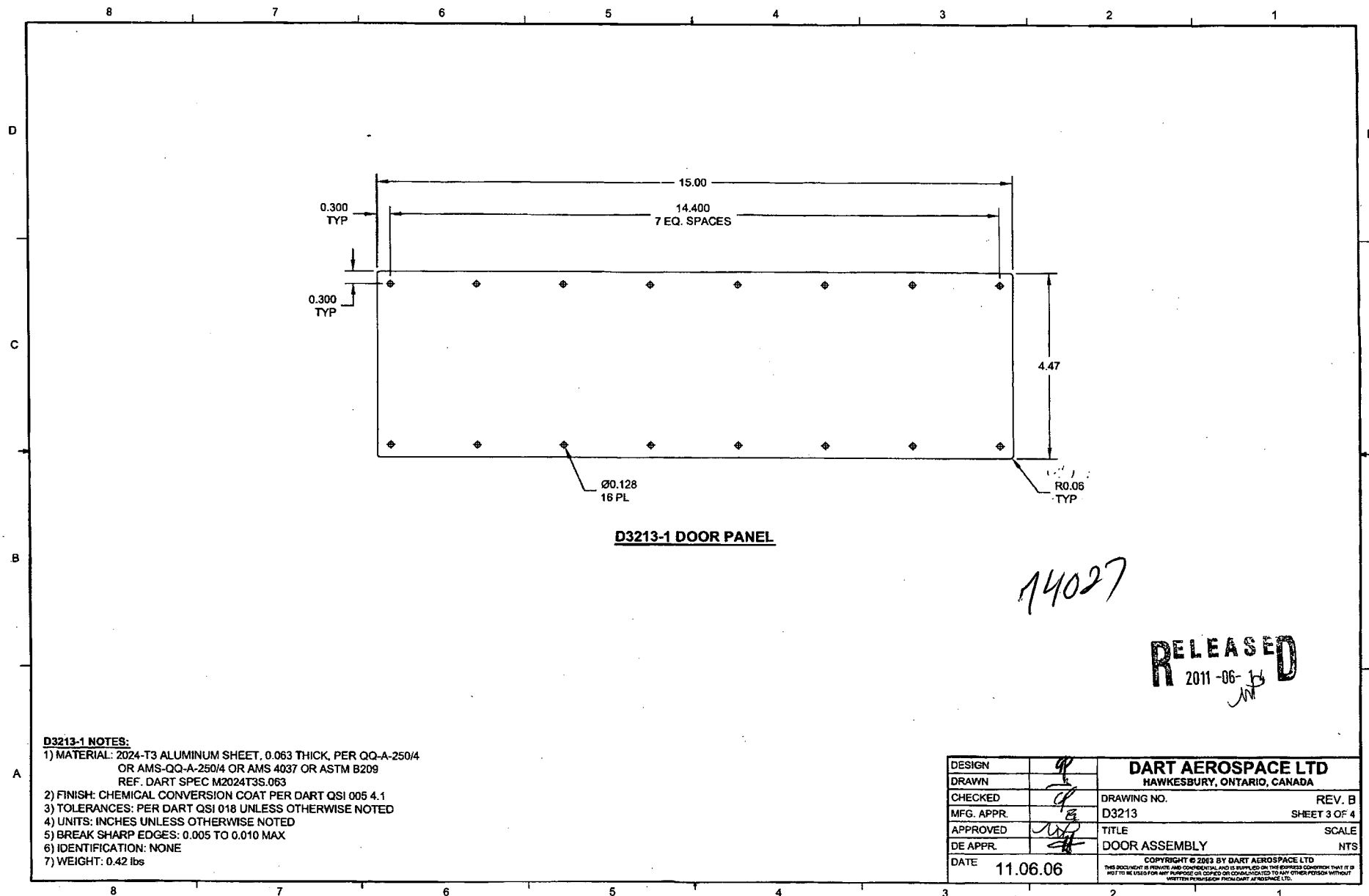
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